

Work Order ID **78947**

Tuesday, January 17, 2012 1:53:22 PM

78947

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Item ID: D3121-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap

Start Date: 1/17/2012 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 1/18/2012 Req'd Qty: 200.00 ***200*** Customer:

Reference:

12-01-17

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3121	Rev E

100	Hardinge CNC LATHE SMALL	0.00	<i>SC 120</i>	<i>12/01/18</i>	<i>200</i>	<i>0</i>	<i>12/01/19</i>
100							
Hardinge	Memo	0.00					
Hardinge CNC Lathe Small	1-Turn D3121-25 Cap as per Folio FA3872-Deburr						
110	QC2- Inspect parts off machine FAI/FAIB	0.00	<i>SC 120</i>	<i>12/01/18</i>	<i>200</i>	<i>0</i>	<i>12/01/19</i>
110							
QC	Memo	0.00					
Quality Control							
120	QC8- Inspect parts - second check	0.00	<i>BA</i>	<i>12/01/19</i>	<i>200</i>	<i>0</i>	
120							
QC	Memo	0.00					
Quality Control							

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Item ID: D3121-25

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 1/17/2012 Start Qty: 200.00

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Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 200.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>235</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

M.L.W 12/01/20

200

Picklist Print

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Work Order ID: 78947

Parent Item: D3121-25

Parent Item Name: Cap

Start Date: 1/17/2012

Required Date: 1/18/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:A New Issue 06-05-10 JLM
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 DELRIN ROUND BAR 1.25"		Purchased	No			100	f	25.4490	0.052	10.947368			

Location

MAT055

Loc Qty

25.449

Loc Code

114586

1.449

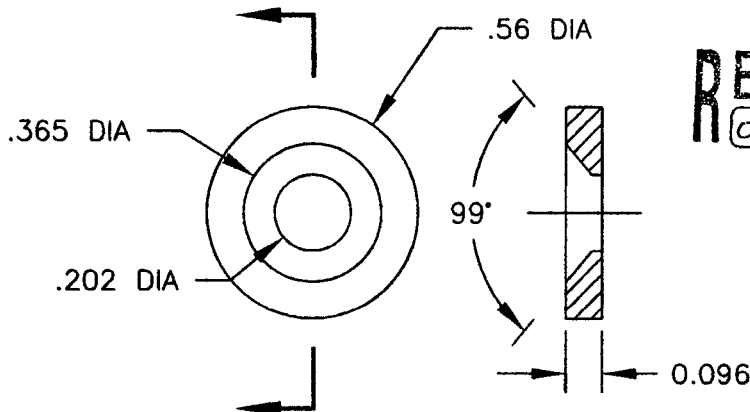
119133

24

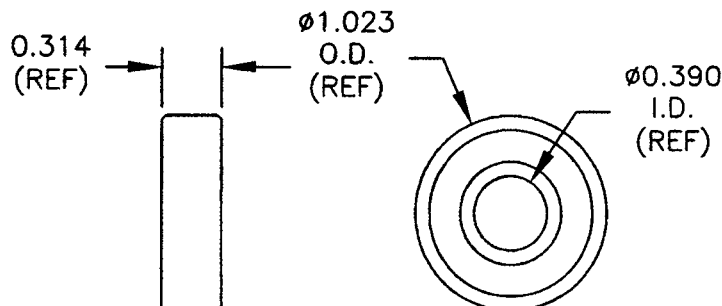
7.417

DART

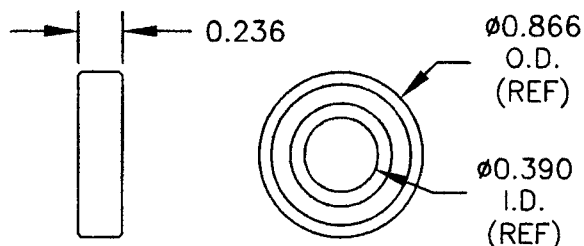
DESIGN <i>[Signature]</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

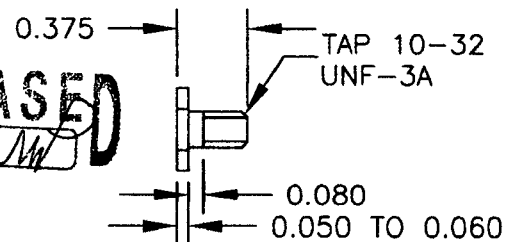
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

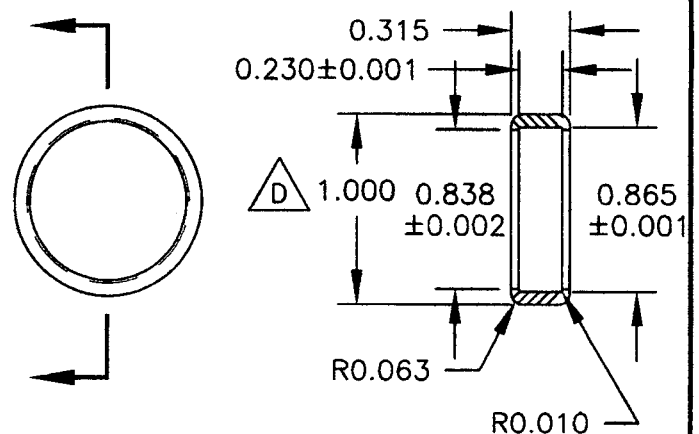
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

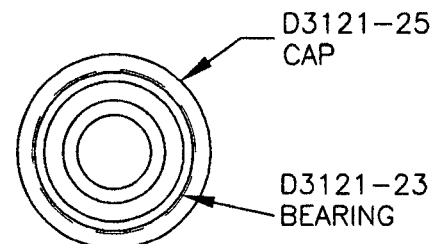
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.11.07 *[Signature]***D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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